

SETUP & OPERATION MANUAL

FEATURES

- Heavy duty cast-iron head, column and base built for steady vibration free performance.
- Head slides on precision machined cast-iron dovetail ways - stroke is controlled by a gas head-cylinder for smooth operation.
- Head tilts up to 30° left or right for angled mortising, and pivots up to 180° for off table mortising.
- Adjustable head height extends working capacity by up to 3" (up to 9" under chisel), to accommodate work with taller workpieces.
- Equipped with easy to adjust dual depth stop for complete control of both down stroke depth and upstroke travel.
- Large feed handle with extra long, multi-position arm for better leverage and increased feed control.
- Includes an adjustable workpiece stop, handwheel controlled clamp and a column mounted hold-down.
- Totally enclosed fan cooled (T.E.F.C.) motor with start capacitor for smooth start-up and longer running life.
- Dust protected on/off switch.
- Includes adapter bushings to accommodate both 5/8" and 3/4" sized chisel shanks.

SPECIFICATIONS

CHISEL CAPACITY

1/4" TO 5/8" (6 TO 16 MM)

MAXIMUM CHISEL STROKE

9" (228 MM)

DISTANCE FROM FENCE TO CHISEL CENTER

4" (102 MM)

DISTANCE FROM CHISEL TO TABLE

(CHISEL 1/4")

6" TO 9" (152 MM TO 228 MM)

CHUCK CAPACITY

1/2" (13 MM)

FENCE SIZE

14 1/8" X 2 7/8"

TABLE SIZE

13 1/2" X 9" (343 X 230 MM)

BASE SIZE

14 1/8" X 10 3/8" (360 X 265 MM)

OVERALL HEIGHT

29" (736 MM)

SPINDLE SPEED

1720 RPM

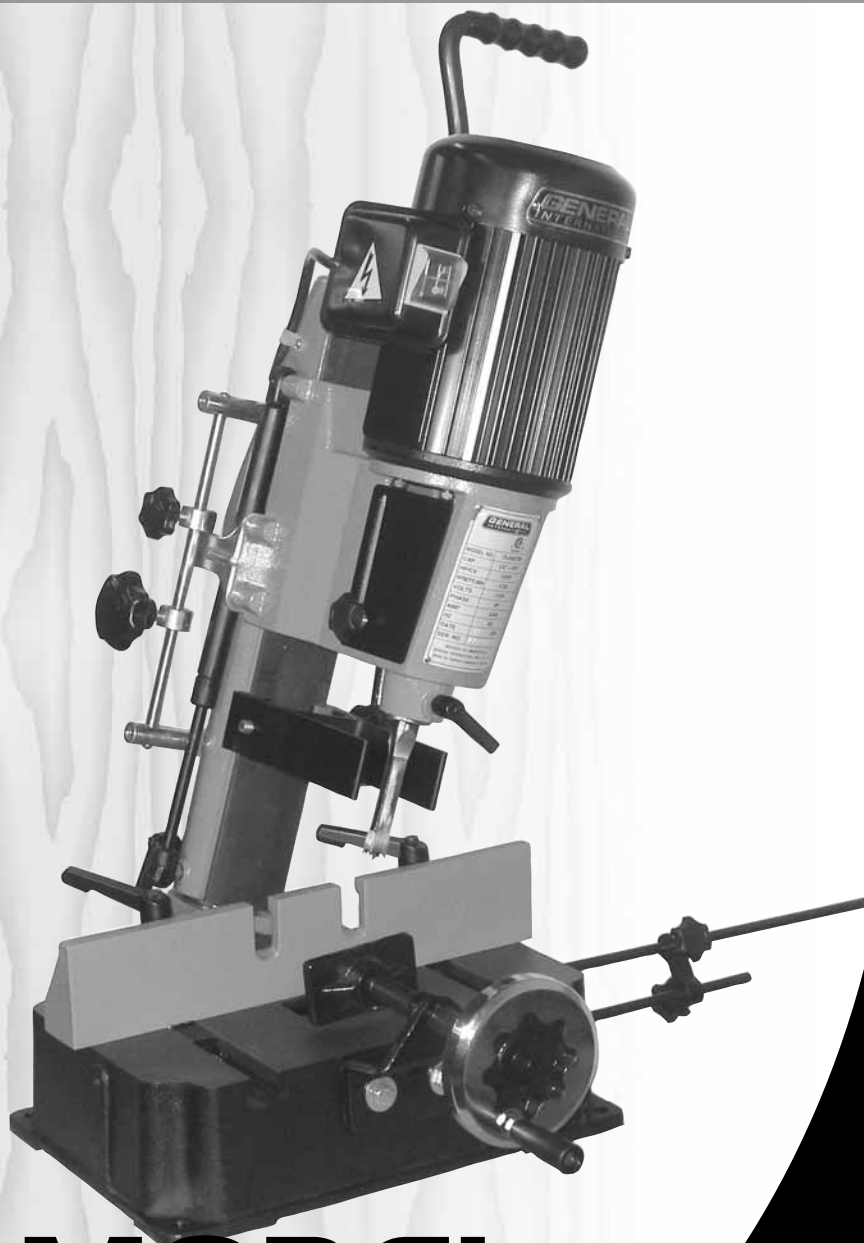
MOTOR

1/2 HP, 110 V, 1 Ph, 3.8 A

WEIGHT

106 LBS (48 KG)

5/8" TILTING HEAD HOLLOW CHISEL MORTISER



MODEL #75-050T MI



VERSION 2_REVISION 2 - January 27/09
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GENERAL® INTERNATIONAL

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THANK YOU for choosing this General® International model 75-050T M1 5/8" tilting head hollow chisel mortiser. This mortiser has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. To ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this mortiser as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with

that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of mortiser and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

GENERAL® & GENERAL® INTERNATIONAL WARRANTY

All component parts of General®, General® International and Excalibur by General International® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. *However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.*

Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

CONDITIONS AND EXCEPTIONS:

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® or General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

Repairs made without the written consent of General® International will void all warranty.

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RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Do not operate the mortiser when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the mortiser is in operation; do not permit them to operate the mortiser.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. **Stay alert!** Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector and wear eye, ear and respiratory protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the mortiser is in operation.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the table surface before operating.
9. Keep hands well away from the mortising chisel, bit and all moving parts. Use a hold-down or clamp to secure the stock, and use a brush, not hands, to clear away chips and dust.
10. Be sure that the mortising chisel and bit are securely installed in the chuck before operation.
11. Be sure the mortising bit has gained full operating speed before beginning to drill.
12. Always use a clean, properly sharpened chisel and bit set. Dirty or dull chisels and bits are unsafe and can lead to accidents.
13. Use suitable work piece support if the work piece does not have a flat surface.
14. Do not push or force the chisel and bit into the stock. The mortiser will perform better and more safely when working at the rate feed for which it was designed.
15. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor.
16. Never leave the machine unattended while it is running or with the power on.
17. Use of parts and accessories NOT recommended by GENERAL® INTERNATIONAL may result in equipment malfunction or risk of injury.
18. Never stand on machinery. Serious injury could result if the tool is tipped over or if the mortiser chisel and bit are unintentionally contacted.
19. Always disconnect the tool from the power source before servicing or changing accessories such as chisel and bit sets, or before performing any maintenance, cleaning, or if the machine will be left unattended.
20. Make sure that the switch is in the "OFF" position before plugging in the power cord.
21. Make sure the tool is properly grounded. If equipped with a 3-prong plug, it should be used with a three-pole receptacle. Never remove the third prong.
22. Do not use this mortiser for other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real implied warranty and holds itself harmless for any injury, which may result from that use.

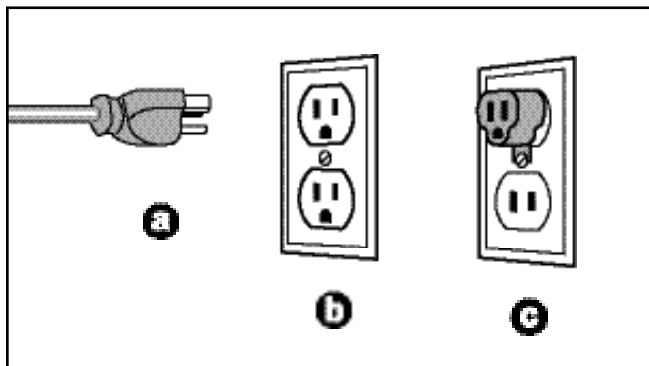


ELECTRICAL REQUIREMENTS



BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.



GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock. The motor of this machine is wired for 110V single phase operation and is equipped with a 3-conductor cord and a 3-prong grounding plug (a) to fit a grounded type receptacle (b). Do not remove the 3rd prong (grounding pin) to make it fit into an old 2-hole wall socket or extension cord. If an adaptor plug is used (c), it must be attached to the metal screw of the receptacle.

Note: The use of an adaptor plug is illegal in some areas. Check your local codes. If you have any doubts or if the supplied plug does not correspond to your electrical outlet, consult a qualified electrician before proceeding.

CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS

If you find it necessary to use an extension cord with your machine, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

Make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

TABLE - MINIMUM GAUGE FOR CORD

AMPERE RATING	TOTAL LENGTH OF CORD IN FEET				
	110 VOLTS	25 FEET	50 FEET	100 FEET	150 FEET
	220 VOLTS	50 FEET	100 FEET	200 FEET	300 FEET
	AWG				
< 5	----->	18	16	16	14
6 TO 10	----->	18	16	14	12
10 TO 12	----->	16	16	14	12
12 TO 16	----->	14	12	* NR	* NR

* NR = Not Recommended



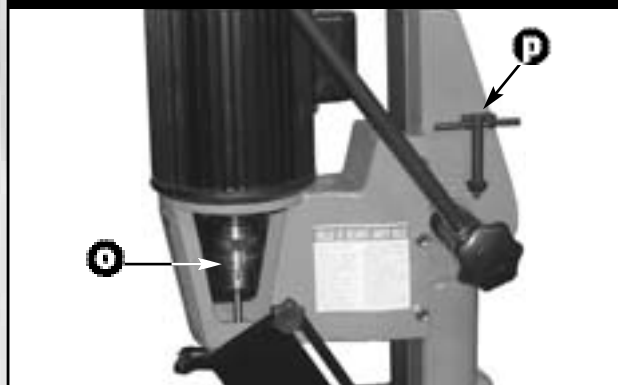
5/8" TILTING HEAD HOLLOW CHISEL MORTISER 75-050T M1

IDENTIFICATION OF MAIN PARTS AND COMPONENTS

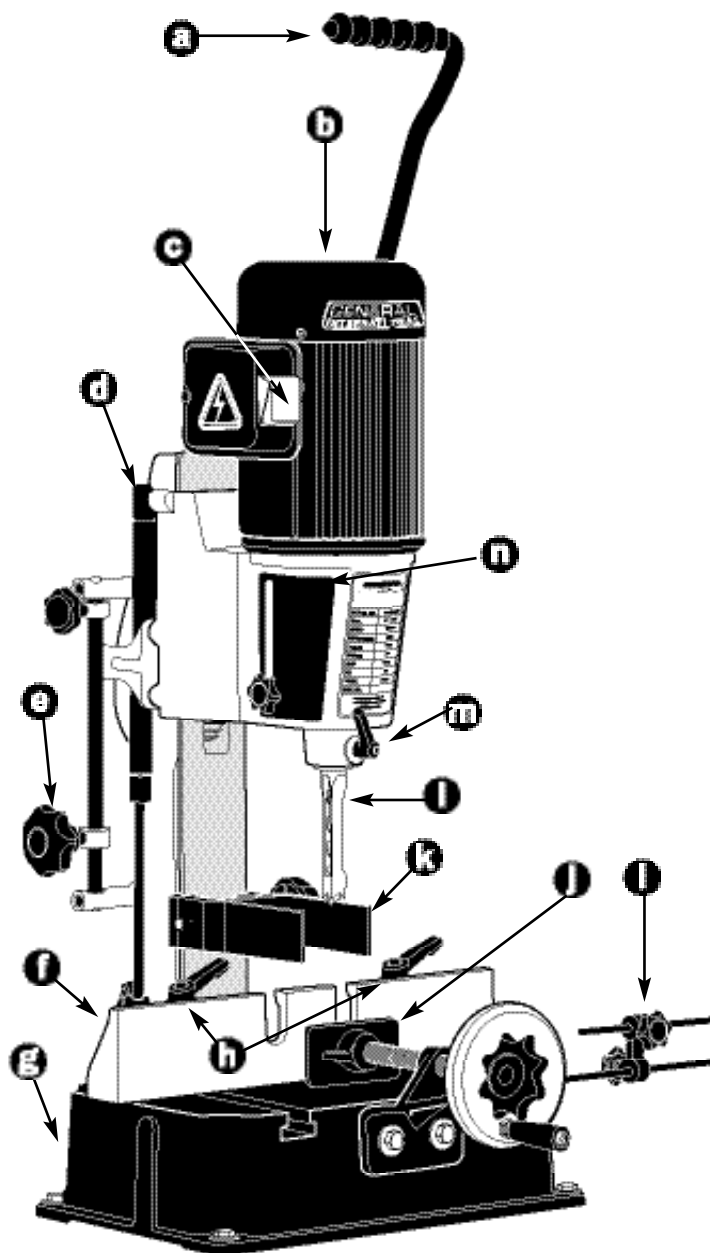
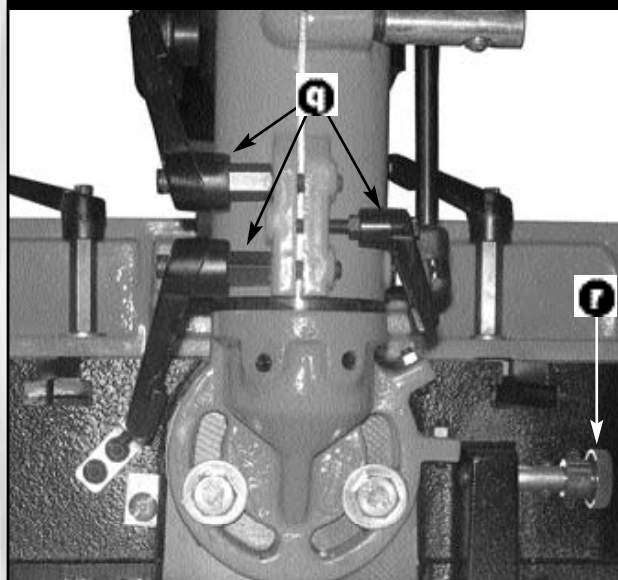
LEFT SIDE VIEW

- a** DOWNFEED HANDLE
- b** MOTOR
- c** ON/OFF SWITCH
- d** GAS HEAD-CYLINDER
- e** DEPTH STOP
- f** FENCE
- g** BASE
- h** FENCE LOCKING LEVERS
- i** WORKPIECE STOP
- j** WORKPIECE CLAMP
- k** WORKPIECE HOLD-DOWN
- l** CHISEL AND BIT
- m** CHISEL LOCKING LEVER
- n** SLIDE PLATES

RIGHT SIDE VIEW



REAR VIEW



- o** CHUCK
- p** CHUCK KEY AND HOLDER
- q** RATCHET LEVERS
- r** STOP PIN

BASIC FUNCTIONS

This tilting head hollow chisel mortiser is designed to cut 90° and/or angled mortises in solid wood as well as other wood based stock. With its tilting, pivoting and extendable height head, the 75-050TM1 is designed to tackle a wide range of mortising applications suited to both hobbyist and professional users.

Ideal for use in any furniture making or cabinet making applications that require mortise and tenon joinery, the unit is supplied with a set of 4 different sized chisel and bits to help the user cut mortises of varying widths to suit the application. The unit is also supplied with 2 different sized chisel bushings, allowing the user to install chisel and bit sets of either 5/8" (4 supplied) or 3/4" (commonly available from other after-market sources) shank diameter.

This mortiser is designed to accommodate chisel and bit set sizes ranging from a minimum of 1/4" up to a maximum of 5/8".

UNPACKING

Carefully unpack and remove the mortiser and its components from the box and check for damaged or missing items as per the list of contents below.

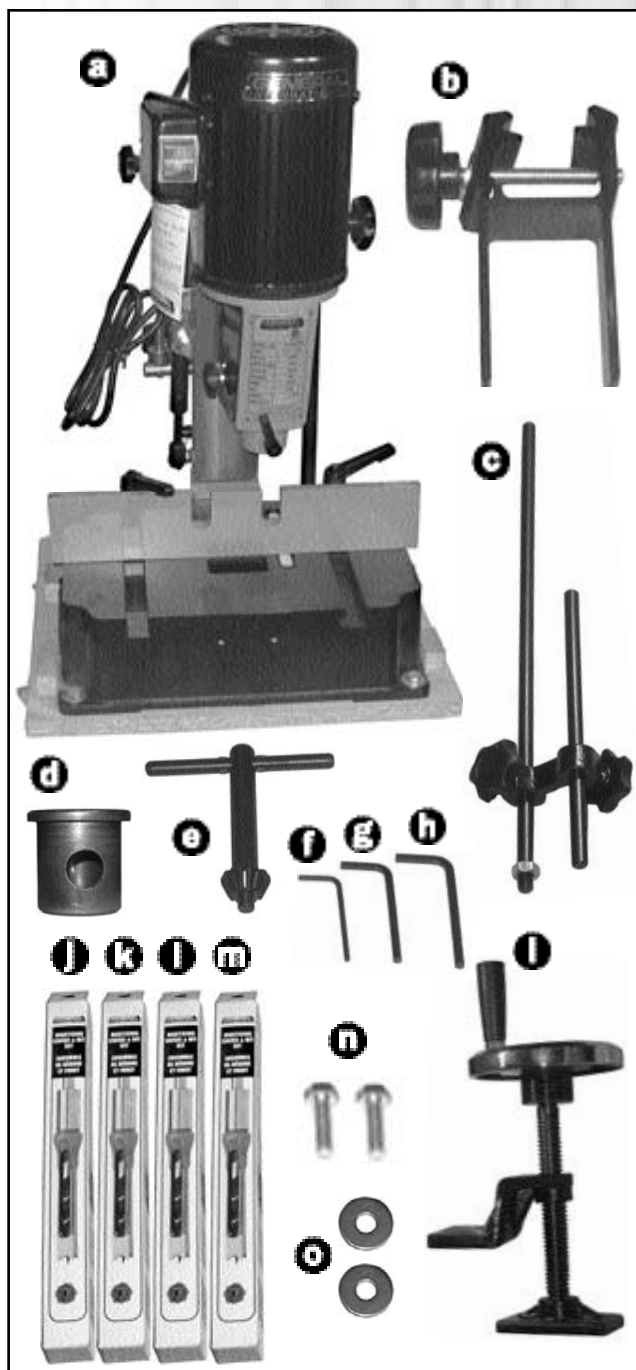
NOTE: Please report any damaged or missing items to your General International distributor immediately.

LIST OF CONTENTS

	QTY
A MORTISER.....	1
B WORKPIECE HOLD-DOWN	1
C WORKPIECE STOP	1
D 3/4" SHANK BUSHING ADAPTER.....	1
E CHUCK KEY.....	1
F 3 MM ALLEN KEY	1
G 4 MM ALLEN KEY	1
H 5 MM ALLEN KEY	1
I WORKPIECE CLAMP	1
J 1/4" - 6 MM CHISEL AND BIT.....	1
K 5/16" - 8 MM CHISEL AND BIT.....	1
L 3/8" - 10 MM CHISEL AND BIT.....	1
M 1/2" - 13 MM CHISEL AND BIT.....	1
N HEX HEAD BOLT	2
O FLAT WASHER.....	2

ADDITIONAL REQUIREMENTS FOR SET UP

- 13 & 17 mm socket or open end wrench



PREPARATION AND INSTALLATION



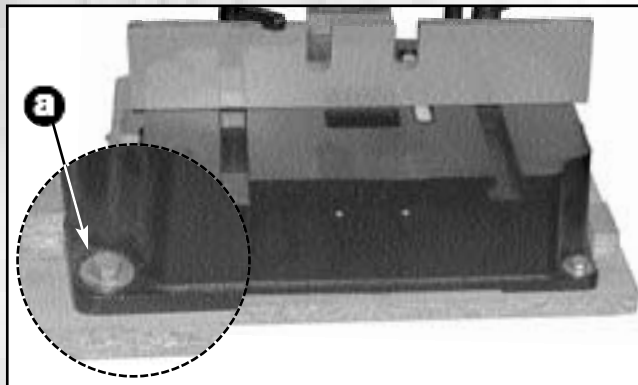
SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.

CLEAN UP

Clean all rust protected surfaces by rubbing with a rag dipped in kerosene, mineral spirits or paint thinner. (Dispose of potentially flammable solvent-soaked rags according to manufacturer's safety recommendations.) Avoid rubbing any painted surfaces, as many solvent-based products will remove paint.

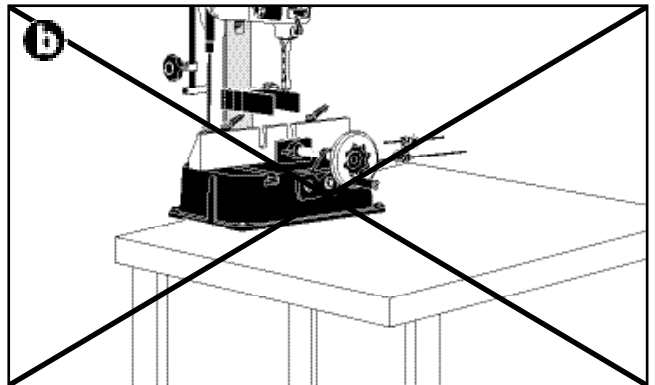
To prevent rust, apply a light coating of paste wax or use regular applications of any after-market surface protectant or rust inhibitor.

DETACH THE MORTISER FROM ITS SHIPPING BASE



Unscrew the 4 shipping bolts **a** using a 13 mm socket or open end wrench, then remove the mortiser from the protective plywood shipping base.

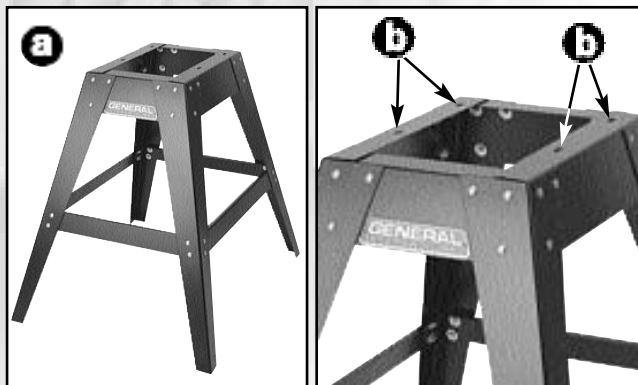
INSTALLATION



This machine should be installed and operated only on a flat, sturdy and stable surface able to support the weight of the machine (92 lbs - 42 kg) and the work-piece with ease.

NOTE: Never install the machine over the edge of a table or workbench **b**.

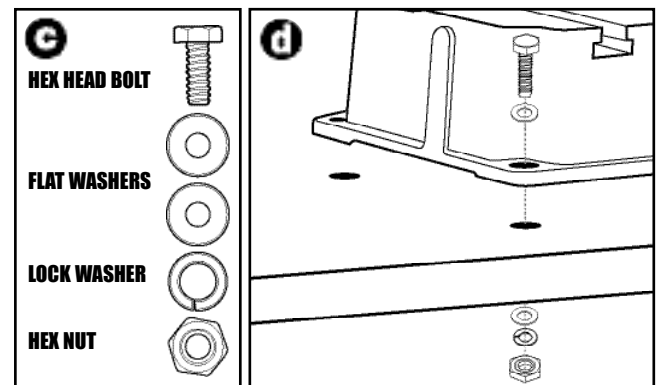
OPTIONAL STAND



If you prefer an optional stand, item 75-045 Heavy-duty open stand **a** is available from your local General International dealer.

NOTE: For use with this machine, the use of a plywood (or other) platform (not supplied) is required to cover the opening in the top of the stand. The platform must be bolted to the stand through the mounting holes **b**.

MOUNTING TO A WORK SURFACE



If a permanent shop placement is practical, consider drilling matching through holes in the mounting surface of your workbench or stand's platform to bolt the mortiser in place using hex bolts, flat washers, lock washers and hex nuts **c** (fasteners not included), in the assembly order shown in **d**.



FOR YOUR SAFETY IT IS ESSENTIAL THAT THE MORTISER DOES NOT ROCK OR TIP DURING OPERATION. MAKE SURE THAT THE MORTISER IS FIRMLY SECURED TO THE WORK SURFACE OR STAND'S PLATFORM AND THAT THERE IS NO ROCKING, TIPPING OR CHATTERING.

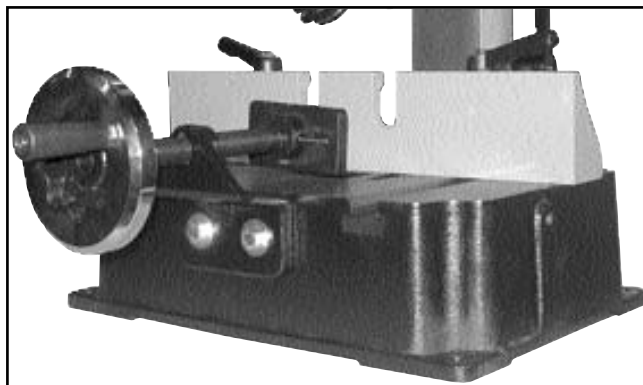
ASSEMBLY INSTRUCTIONS

For your convenience this mortiser is shipped from the factory partially assembled and requires only minimal assembly and set up before being put into service.



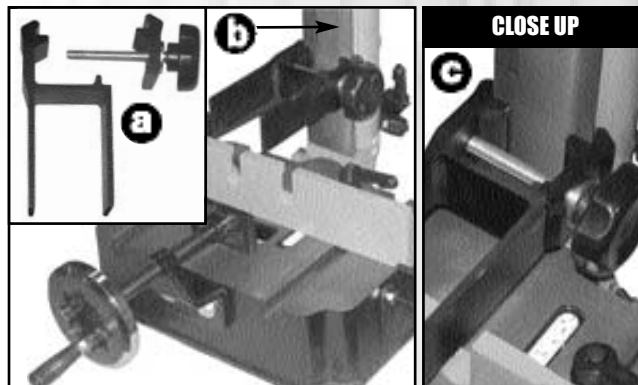
SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.

ATTACH THE WORKPIECE CLAMP



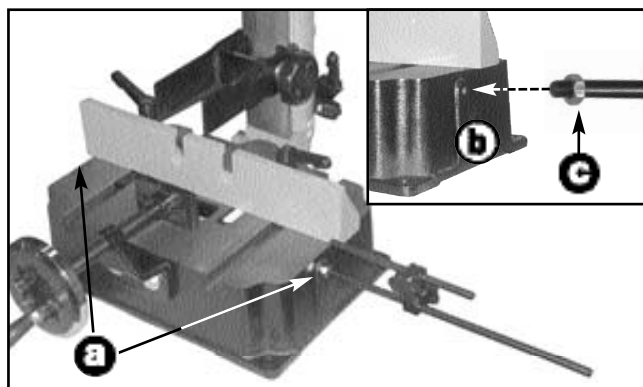
Attach the workpiece clamp assembly to the front of the base with the two supplied hex bolts and flat washers as shown, using a 13 mm socket or open wrench.

ATTACH THE WORKPIECE HOLD DOWN



Separate the two parts of the workpiece hold down assembly **a** then re-assemble them on both sides of the dovetail way **b** as shown in **c**.

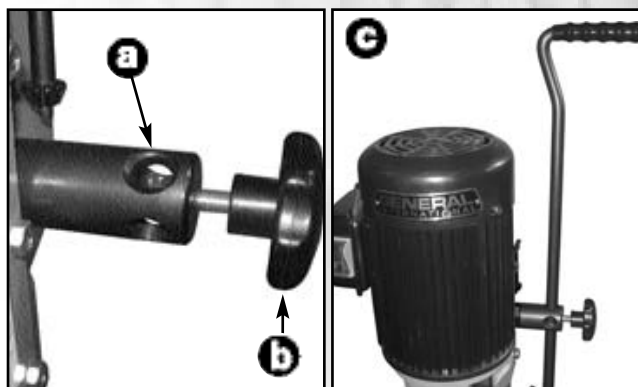
ATTACH THE WORKPIECE STOP



The workpiece stop can be installed on either side of the mortiser **a** to suit your needs or personal work preferences.

1. Thread the workpiece stop into the threaded hole in the base **b**.
2. Secure with the lock nut **c**.

INSTALL THE DOWN FEED HANDLE



The four holes in the down feed shaft **a** allow you to reposition the handle in the holes for better comfort and convenience.

1. Loosen the lock knob **b**.
2. Remove the handle and reposition it as needed, choosing the hole that provides the most comfortable handle angle.
3. Re-tighten the lock knob to secure the down feed handle in position **c**.

INSTALL A CHISEL AND BIT SET

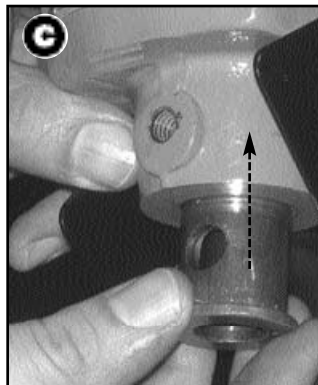
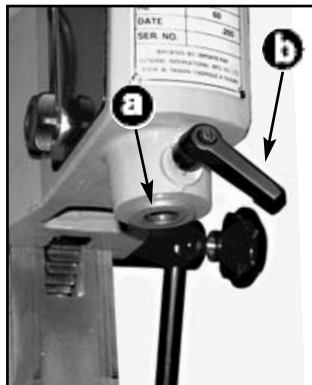


TURN OFF AND UNPLUG THE MORTISER FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE, ADJUSTMENTS OR BIT CHANGES.

CHISEL AND BIT TIPS ARE VERY SHARP – HANDLE WITH CARE. TO AVOID PERSONAL INJURY USE A PIECE OF CARDBOARD, PLASTIC OR OTHER MATERIAL BETWEEN YOUR FINGER AND THE TIP OF THE BIT WHENEVER HOLDING OR HANDLING THE CHISEL AND BIT BY THE TIP.

This unit is supplied with a set of four different sized chisel and bits to help the user cut mortises of varying widths to suit the application.

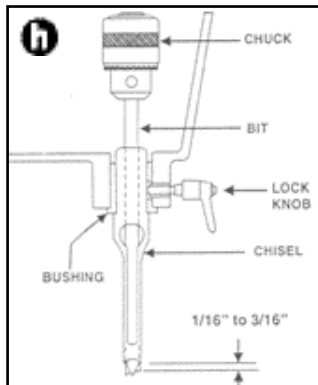
1. Select the appropriate size of chisel and bit.



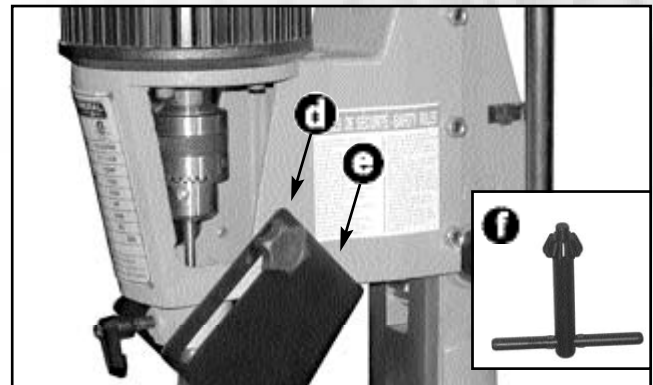
The unit is also supplied with 2 different sized chisel support bushing adapters allowing the user to install chisel and bit sets of either 5/8" or 3/4" shank diameter, to accommodate bit sizes (some of which are available as optional accessories) ranging from a minimum of 1/4" up to a maximum of 5/8":

NOTE: The 5/8" shank diameter bushing is already installed at the factory.

2. Select the appropriate bushing and, if not already installed, unscrew and remove the locking lever **a** then slip the bushing into the quill assembly as shown, **c**.



5. With a piece of plastic, cardboard or wood held between the tip of the bit and your finger, install the chisel and bit with the chip clearing slot facing either left or right **e** and tighten the bit in the chuck so that the tip of the bit juts out approximately 1/16" to 3/16" (2 mm to 5 mm) from the tip of the chisel **b**.



3. Loosen either of the two lock knobs **d** on the chuck cover and slide the corresponding slide plate out of the way **e**.
4. Insert the supplied chuck key **f** and turn counter-clockwise to open the chuck jaws and allow a drill bit to fit in.

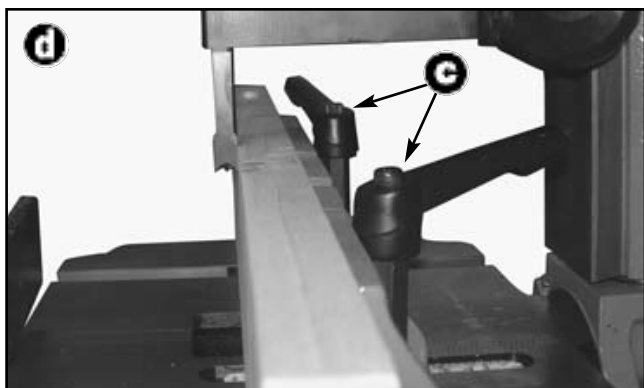
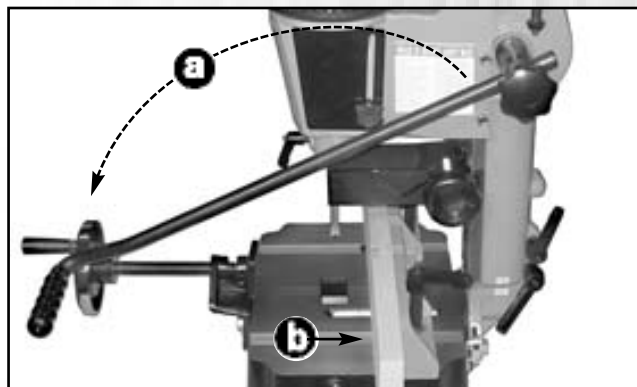


6. While still holding the chisel in place, tighten the locking lever **i** to secure the chisel in the bushing.

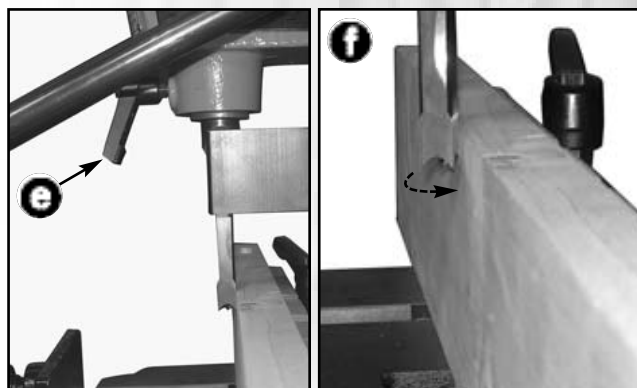
NOTE: Do not overtighten the locking lever as this can damage your mortiser.

TO SQUARE THE CHISEL TO THE FENCE

1. Lower the head to its maximum **a**.
 2. Place a piece of taller stock (minimum 3") against the fence **b**.
- NOTE: Make sure you are using a piece of planed and squared stock that has an even thickness.**
3. Loosen the fence locking levers **c** and slowly advance the fence with the piece of wood towards the chisel.



If the face of the chisel sits flush against the stock **d** the chisel is square. Tighten the chisel locking lever and proceed with normal operation.



If the chisel does not sit flush:

1. Loosen the chisel lock lever **e** and manually turn the chisel **f** until its face sits flush against the stock.
2. Lock the lever to secure the chisel in position.

BASIC ADJUSTMENTS & CONTROLS

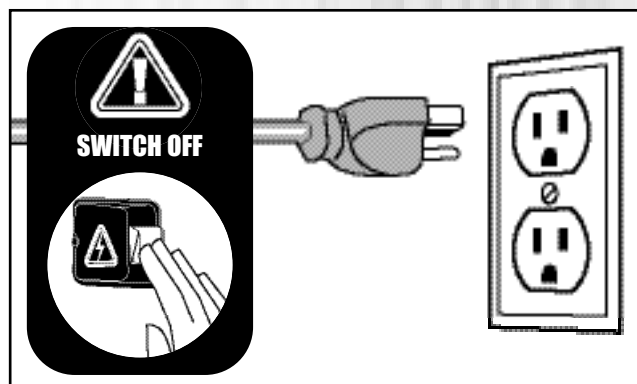
CONNECTING TO A POWER SOURCE



TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY.

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

Once the assembly steps have been completed and the unit is safely secured to a work surface, uncoil the power cord and plug the power cord into an appropriate outlet. Refer back to the section entitled "ELECTRICAL REQUIREMENTS" and make sure all requirements and grounding instructions are followed. When mortising operations have been completed unplug the mortiser from the power source.



ON/OFF POWER SWITCH

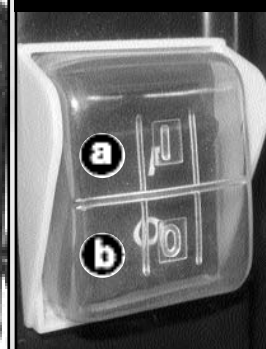


VERIFY ALL FOLLOWING CHECK POINTS BEFORE TURNING ON THE MORTISER. FAILURE TO COMPLY CAN RESULT IN SERIOUS INJURIES.

- MAKE SURE THE TWO SLIDE PLATES OF THE CHUCK COVER ARE CLOSED AND THEIR LOCK KNOBS ARE TIGHTENED SECURELY.
- MAKE SURE THE CHISEL AND BIT ARE PROPERLY INSTALLED AND THAT THE BIT CHUCK AND CHISEL LOCK LEVER ARE TIGHTENED SECURELY.
- WHEN THE MORTISER IS RUNNING CHECK TO SEE IF IT RUNS WITHOUT VIBRATION OR SHAKING.



CLOSE UP

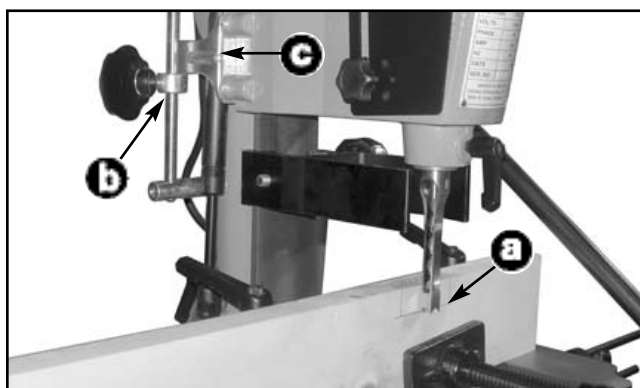


The mortiser is equipped with a rocker style ON/OFF dust-proof switch located on the front left hand side of the mortiser head.

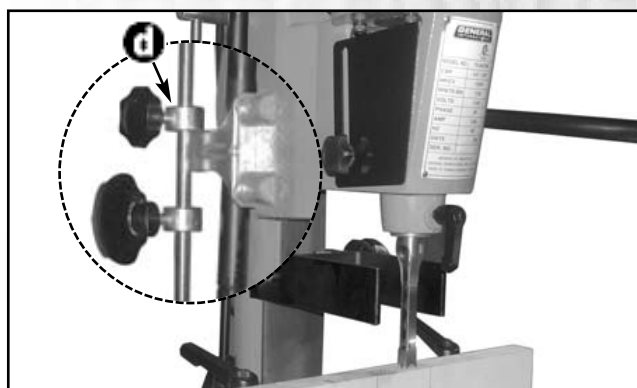
- To start the mortiser, push on the upper portion of the switch **a**;
- To stop the mortiser, push on the lower portion of the switch **b**.

SETTING THE DEPTH STOP

Transfer a reference line showing the desired depth of cut onto the front face of the workpiece and then set the depth stop as follows:



1. Lower the chisel to the bottom of your depth reference line **a** then adjust the depth stop **b** against the stop plate **c** as shown to prevent the chisel from lowering any further.

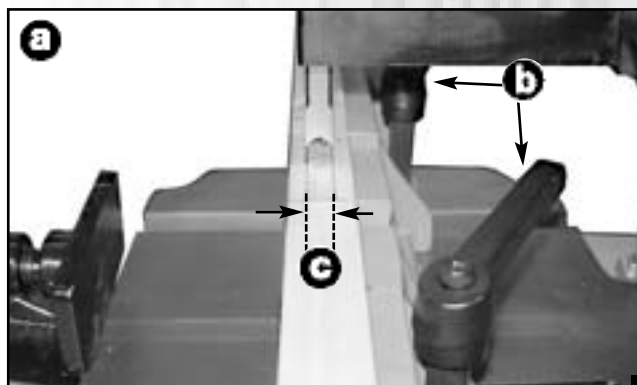


NOTE: As a time saving convenience, the upper stop **d** can be set to control the upward travel of the head. This feature allows you to save time by raising the bit only enough to clear the workpiece and allow you to reposition the workpiece without having to raise the head to its maximum.

BASIC OPERATIONS

1. Layout and mark workpieces for the mortises to be cut.
2. Install the appropriate chisel and bit in the chuck.
3. Place the stock on the table against the fence **a**.
4. Set the depth stop.
5. Loosen the fence locking levers **b** and adjust the fence until the workpiece is positioned with the mortise to be cut centered on the chisel **c**.

NOTE: If necessary, lower the chisel onto the workpiece to make sure the layout lines of the mortise are aligned with the bit.



6. With the fence now set to the correct front to back position, tighten the two fence locking levers to hold the fence in place.
7. So that the chips are discharged into the part of the mortise which is already cut, and that the part to be cut remains well visible, set the workpiece on the table with the bit aligned with either:
 - The left end of the mortise if the chip clearing slot is facing left ❶;
 - The right end of the mortise if the chip clearing slot is facing right ❷;

NOTE: To avoid overheating or damage to the chisel or bit, do not position the slot against the blind end of the mortise as this would prevent the chips from discharging from the chisel.

8. If multiple workpieces are to be mortised in an identical manner, adjust the workpiece stop ❶ to allow to position the next workpiece at the exact same location.
9. Tighten the workpiece clamp ❸ to hold the workpiece securely against the fence.
10. Lower the workpiece hold down until slightly above the workpiece ❶ and tighten.
11. Turn on the machine.
12. Lower the chisel into the workpiece ❶ using a steady even pressure until it bottoms out on the depth stop.

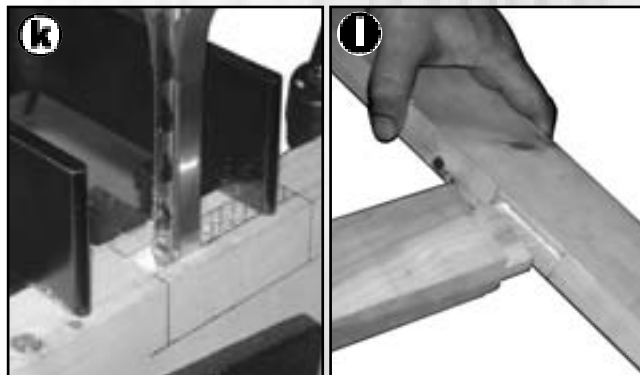
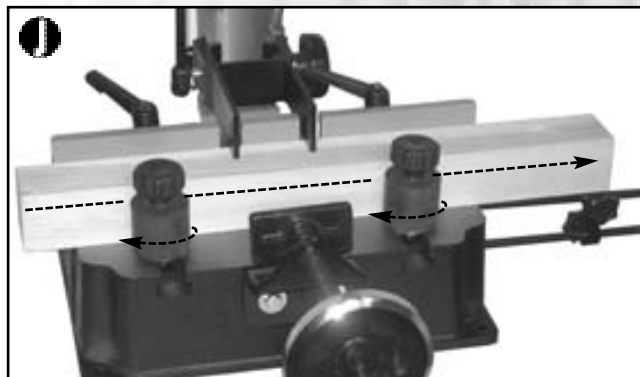
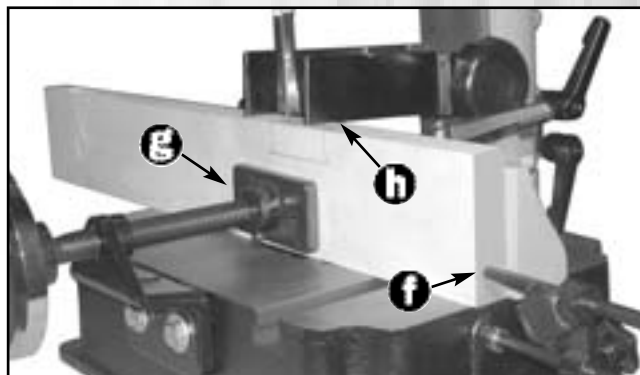
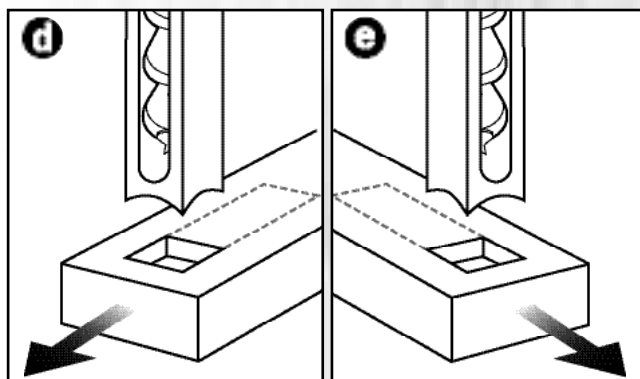
FEED RATE:

NOTE: To prevent burning of the tip of the bit, a steady feed rate is required. The machine may stall or slow down if the feed rate is too fast

TIP: To allow chips to discharge when cutting deeper mortises or through mortises, cut the mortise to its full depth in several steps, by backing off periodically at roughly 3/8" - 1/2" intervals. Raising the bit back out of the mortise briefly, before plunging back in, allows the chips to discharge more easily and can contribute to longer chisel and bit life and cleaner sharper mortises.

When cutting through mortises, place a piece of scrap wood under the workpiece to help prevent tear-out as the bit cuts its way through the opposite or exit face of the workpiece.

13. Raise the chisel.
 14. Loosen the workpiece clamp slightly, and reposition the workpiece against the fence to continue the cut.
- TIP:** For added convenience and time savings when cutting longer mortises, optional rollers, item 75-055 (available from your General® International dealer) can be used instead of the workpiece clamp, allowing you to "roll" the workpiece left or right ❶ as needed to continue the next cut for the mortise slot.
15. Re-tighten the workpiece clamp.
 16. Continue cutting the mortise.
 17. Repeat to complete the mortise overlapping each cut slightly ❸.
 18. Test the fit of your tenon in the mortise ❶. Re-adjust if needed.



ADDITIONAL ADJUSTMENTS

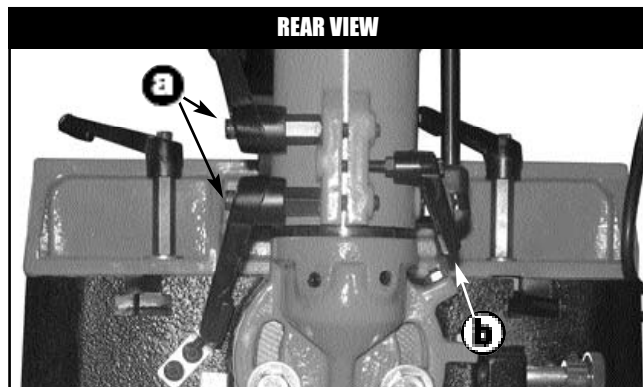
For special applications such as taller workpieces (requiring off table mortising) or for angled mortises, the following machine adjustments can also be made.



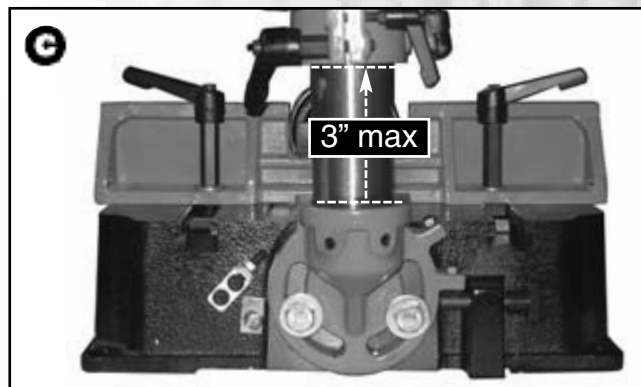
MAKE SURE THE MORTISER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY ADJUSTMENTS.

HEAD HEIGHT ADJUSTMENT

To raise the height of the head and extend the working capacity of the mortiser (if needed) by up to 3":



1. Loosen the two ratchet levers **a**.
2. Slightly tighten the ratchet lever **b**.



3. Manually pull the head 3" up (approx.) **c**.
4. Loosen ratchet lever **b** and tighten ratchet levers **a** to secure the head in position.

HEAD TILT ADJUSTMENT

The head can be tilted to any angle from 0° to 30° to the left or right, to allow for bevel (or angle) mortise cutting.

1. While holding the head, loosen the two bolts **a**, using a 17 mm wrench.

- To set the head 30° left:

Tilt the head towards the left until the tilting bracket rests against the left 30° stop **b**.

- To set the head 30° right:

Pull the stop pin **c** out, then tilt the head towards the right until the tilting bracket rests against the 30° right stop **d**, then release the stop pin.

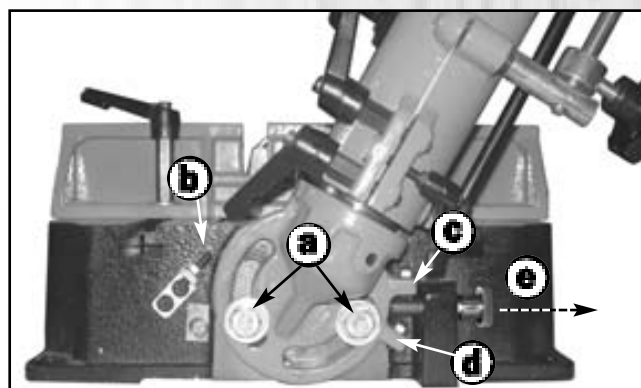
- To set the head back to 0°:

Pull the stop pin **c** out, then tilt the head towards the center until the tilting bracket rests against the 0° stop **e**, then release the stop pin.

- To set the head to any other angle:

To use a setting other than 0° or 30°, refer to the head tilt angle indicator **f** to set the angle of the head to the desired position.

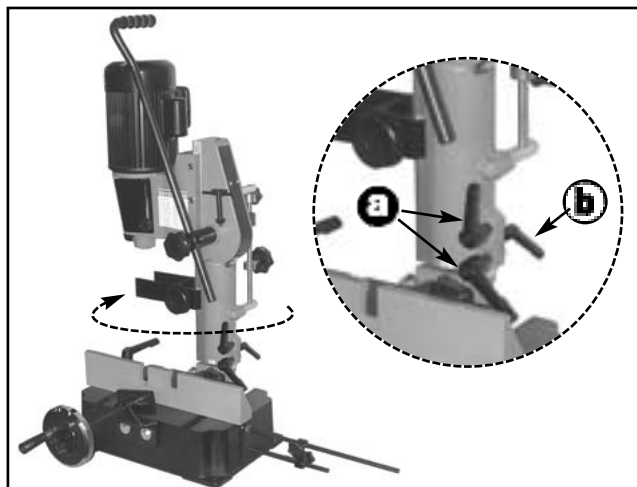
2. Re-tighten the two bolts **a** to secure the head in position.



HEAD SWIVEL ADJUSTMENT

For off-table work, for example with taller workpieces, the entire head of the mortiser can be swivelled up to 180° left or right. To swivel the head:

1. To avoid damaging the chisel and bit or the fence, remove the chisel and bit and move the fence as far as possible towards the front before swivelling the head.
2. Loosen the two ratchet levers **a**.
3. Tighten the ratchet lever **b** then swivel the head to the desired position.
4. Loosen ratchet lever **b** and tighten ratchet levers **a** to secure the head in position.



MAINTENANCE



MAKE SURE THE MORTISER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE.

PERIODIC MAINTENANCE

- Keep the machine clean and free of dust, and woodchips. Vacuum or brush off any loose debris and wipe down the machine and the table occasionally with a damp rag.
- An occasional light coating of paste wax can help protect the table surface and reduce workpiece friction. Ask your local distributor for suggestions on aftermarket surface cleaners and protectants based on what is readily available in your area. (Avoid using silicon based products that may affect wood finishing products such as oil, solvent or water-based stains, varnishes and lacquers.)
- Periodically inspect the power cord and plug for damage. To minimize the risk of electric shock or fire, never operate the mortiser with a damaged power cord or plug. Replace a damaged power cord or plug at the first visible signs of damage.
- Periodically inspect chisel and bits for signs of visible damage. Replace a chipped or damaged chisel or bit immediately.

SHARPENING CHISELS AND BITS

Working with properly sharpened chisel and bits sets will greatly increase the quality of your work and allow you to obtain clean, crisply cut mortises with minimal effort. With use over time chisels and bits will need to be re-sharpened. The frequency of use, type of workpiece material and the size and depth of the mortises you cut will affect how often or infrequently re-sharpening will be required.

You will find there are a variety of aftermarket sharpening tools made by third party sources that are available on the market for both the chisels and the bits for your mortiser. Your local distributor or tool retailer will be able to advise you of any sharpening tool options based on what is readily available in your area.

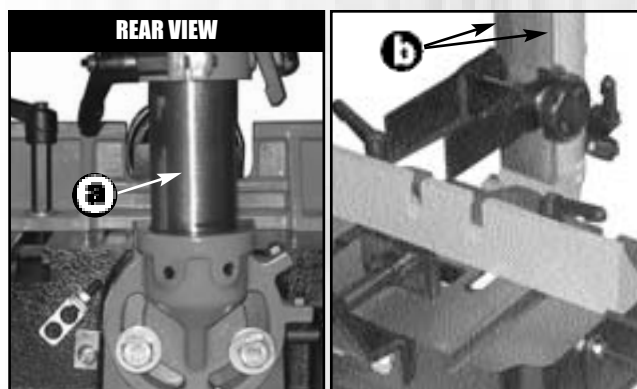
Take note that chisels should only be sharpened on their inside edges as any material removed from the outside edge will affect and change the overall dimensions of the chisel. An example of a typical chisel sharpening cone is shown in **a**. Such cones are usually made available in sets or individually by size and should be matched to the size of the chisel – your local tool distributor or sharpening supplies specialist will be able to advise you further. For best results follow the instructions supplied with the sharpening tool or accessory being used.



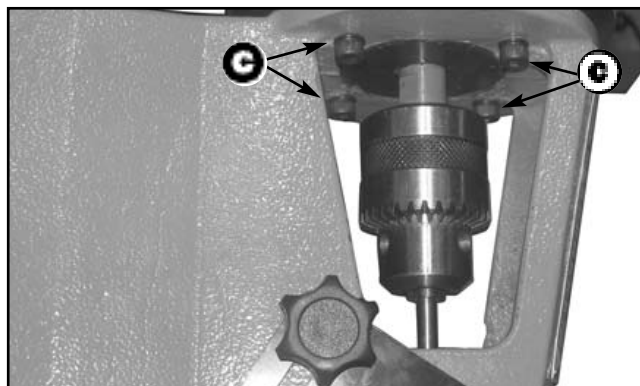
LUBRICATION

Keep the column **a** and both sides of the dovetail way **b** well lubricated and free of dust or debris. Clean and remove dust, debris, and old lubricant as needed depending on frequency of use. After cleaning, reapply a very light coating of lubricant.

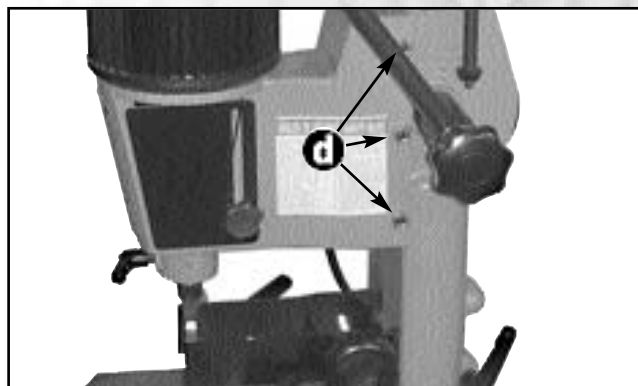
NOTE: Use any all-purpose oil, available at any hardware store).



REQUIRED MAINTENANCE



With use and normal wear over time, the motor assembly may loosen slightly. If you notice abnormal noise or vibrations, tighten the cap screws **c** (accessible behind the slide plates on both sides of the chuck), using the supplied 5 mm allen key.

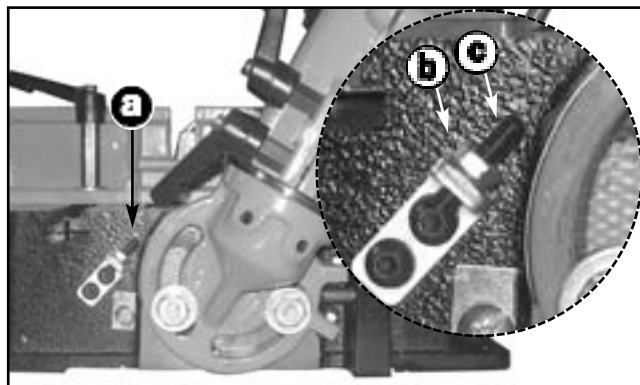


With use over time, some slight play may develop in head on the dovetail way due to wear. To eliminate play between the head and the dovetail way, loosen the lock nuts **d**, and adjust the individual set screws as needed. Re-tighten the lock nut(s) once the adjustment has been completed.

NOTE: Adjust only enough to eliminate play - do not over tighten as this can stiffen or restrict head travel, requiring more effort to complete the feed stroke and cause premature wear of the dovetail way.

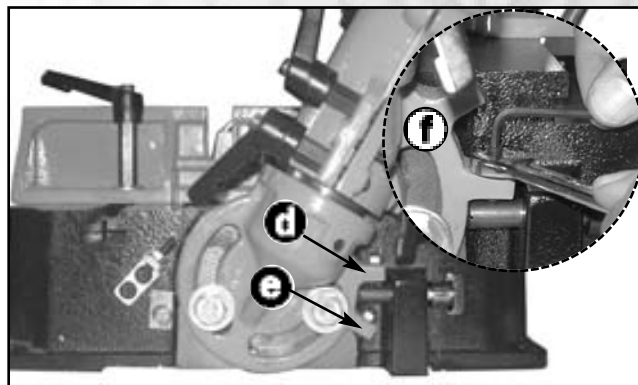
TILT INDEX STOP ADJUSTMENT

The 0°, 30° right and 30° left index stops are factory set. However, with use and vibration over time, they eventually may need minor adjustments.



If the left 30° index stop **a** needs to be adjusted:

1. Loosen the lock nut **b** using a 10 mm wrench.
2. Using the supplied 3 mm Allen key, adjust the set screw **c** in or out until the indicator points toward 30° on the angle scale, then re-tighten the lock nut.



If the right 30° stop **d** or 0° stop **e** needs to be adjusted:

1. Loosen the lock nut using a 10 mm wrench.
2. Using the supplied 3 mm Allen key, adjust the set screw **f** in or out until the indicator points to 30° or 0°, respectively, then re-tighten the lock nut.

RECOMMENDED OPTIONAL ACCESSORIES

Here are some of the optional accessories available from your local General International dealer.

For more information about our products, please visit our website at www.general.ca

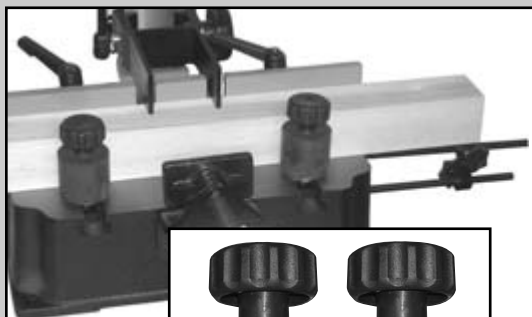


HEAVY-DUTY OPEN STAND **ITEM # 75-045**

Heavy duty adjustable height, flared steel stand. Wide stance design with sturdy cross-bracing for stable vibration-free operation.

- Height: 30 5/8" (778 mm)
- Dimensions at top: 13 1/4" x 18 1/2" (336 x 470 mm)
- Dimensions at feet: 26 1/2" x 33 1/4" (673 x 845 mm)

NOTE: Top opening measures are 9 1/4" x 12 3/4". For use with this machine, the use of a plywood (or other) platform (not supplied) is required to cover the opening in the top of the stand.



MORTISING TABLE ROLLERS (2) **ITEM # 75-055**

For added convenience and time savings when cutting longer mortises. Use rollers instead of the workpiece clamp.

No more clamping and unclamping after each cut! Simply butt the rollers up against the workpiece keeping it tight to the fence; after completing a cut, "roll" the workpiece left or right as needed to continue the next cut for the mortise slot.



REPLACEMENT/OPTIONAL CHISEL & BIT SETS

ITEM # 70-910

1/4" (6 mm) mortising chisel & bit set, 5/8" (16 mm) shank

ITEM # 70-920

5/16" (8 mm) mortising chisel & bit set, 5/8" (16 mm) shank

ITEM # 70-930

3/8" (10 mm) mortising chisel & bit set, 5/8" (16 mm) shank

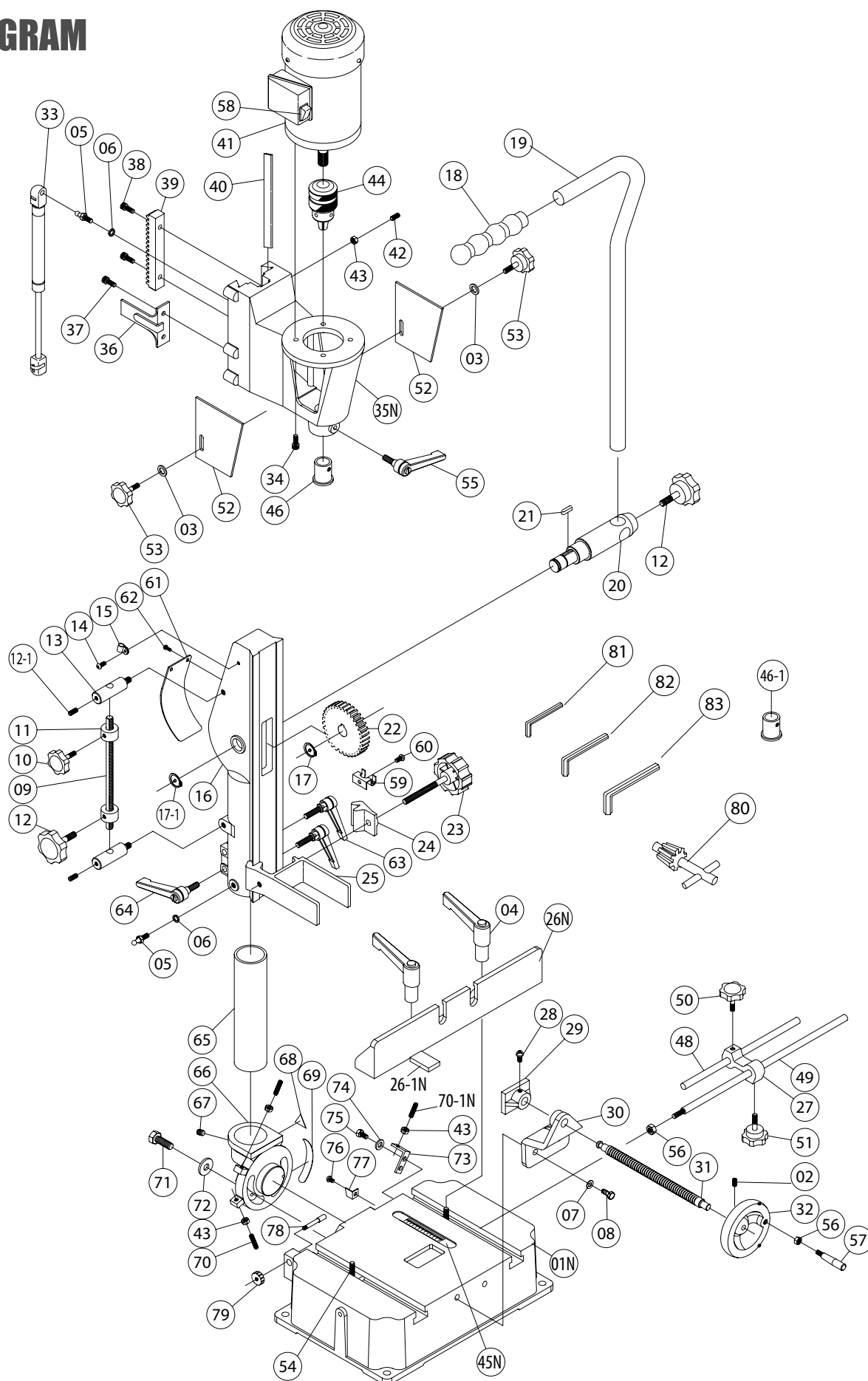
ITEM # 70-940

1/2" (13 mm) mortising chisel & bit set, 5/8" (16 mm) shank

ITEM # 70-950

5/8" (16 mm) mortising chisel & bit set, 5/8" (16 mm) shank

DIAGRAM



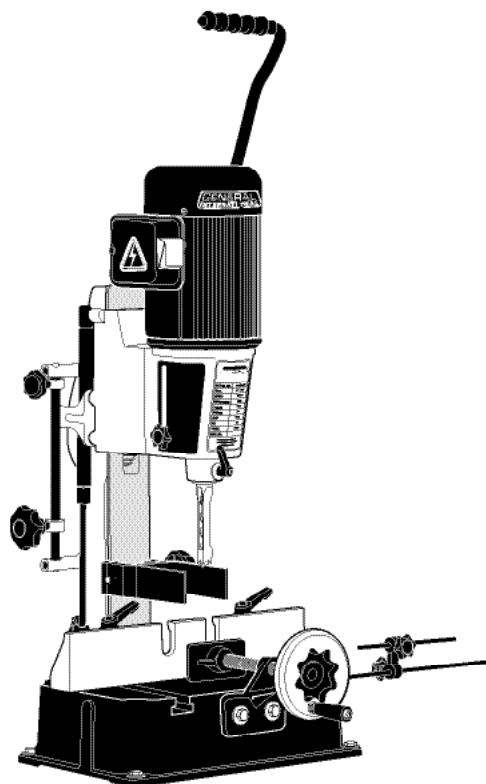
**PARTS LIST
75-050T M1**

PART NO.	DESCRIPTION	QTY	PART NO.	DESCRIPTION	QTY
75050T-01N	BASE	1	75050T-44	CHUCK X 13 MM	1
75050T-02	SET SCREW 5/16 X 3/8	1	75050T-45N	SCALE	1
75050T-03	WASHER 1/4	2	75050T-46	CHISEL BUSHING (5/8 SHANK)	1
75050T-04	RATCHET LEVER M8	2	75050T-46-1	CHISEL BUSHING (3/4 SHANK)	1
75050T-05	SCREW M8	2	75050T-48	STOP BAR (SHORT)	1
75050T-06	LOCK WASHER 3/8	2	75050T-49	STOP BAR (LONG)	1
75050T-07	WASHER 5/16	2	75050T-50	LOCK KNOB	1
75050T-08	HEX HEAD BOLT 5/16 X 1	2	75050T-51	LOCK KNOB	1
75050T-09	DEPTH STOP BAR	1	75050T-52	SLIDE PLATE (CHUCK COVER)	2
75050T-10	LOCK KNOB 5/16 X 3/4	1	75050T-53	LOCK KNOB 1/4	2
75050T-11	ADJUSTING SLEEVE	2	75050T-54	BOLT M 8	2
75050T-12	LOCK KNOB 5/16	2	75050T-55	RATCHET LEVER	1
75050T-12-1	SET SCREW 5/16 X 3/8	2	75050T-56	NUT 5/16	2
75050T-13	STOP BAR SUPPORT POST	2	75050T-57	HANDLE	1
75050T-14	SCREW 3/16	1	75050T-58	SWITCH	1
75050T-15	CORD CLAMP 1/4	1	75050T-59	CHUCK KEY HOLDER	1
75050T-16	COLUMN	1	75050T-60	SCREW 3/16	1
75050T-17	"C" RING 15	1	75050T-61	GEAR COVER	1
75050T-17-1	"C" RING 20	1	75050T-62	SCREW	2
75050T-18	HANDLE GRIP	1	75050T-63	RATCHET LEVER 5/16	2
75050T-19	DOWNFEED HANDLE	1	75050T-64	RATCHET LEVER M6	1
75050T-20	DOWNFEED SHAFT	1	75050T-65	COLUMN EXTENSION POST	1
75050T-21	KEY	1	75050T-66	COLUMN MOUNT BRACKET	1
75050T-22	GEAR	1	75050T-67	SET SCREW	2
75050T-23	LOCK KNOB 3/8 X 90	1	75050T-68	LABEL	2
75050T-24	HOLD DOWN CLAMP ARM	1	75050T-69	ANGLE SCALE	1
75050T-25	HOLD DOWN CLAMP ARM	1	75050T-70	SET SCREW	2
75050T-26N	FENCE	1	75050T-70-1N	SET SCREW M6X25	1
75050T-26-1N	SLIDE BAR	1	75050T-71	HEX HEAD BOLT	2
75050T-27	STOP BAR BLOCK	1	75050T-72	FLAT WASHER	4
75050T-28	SCREW 1/4 X 5/8	1	75050T-73	TILT STOP BRACKET	1
75050T-29	WISE PLATE	1	75050T-74	FLAT WASHER	2
75050T-30N	WISE MOUNT BRACKET	1	75050T-75	HEX HEAD BOLT	2
75050T-31	THREADED ROD	1	75050T-76	SCREW	1
75050T-32	HANDWHEEL	1	75050T-77	POINTER	1
75050T-33	GAS SPRING	1	75050T-78	STOP PIN	1
75050T-34	CAP SCREW 1/4 X 1	4	75050T-79	NUT	1
75050T-35N	MACHINE HEAD	1	75050T-80	CHUCK KEY	1
75050T-36	STOP PLATE	1	75050T-81	3 MM ALLEN KEY	1
75050T-37	CAP SCREW 1/4 X 3/4	2	75050T-82	4 MM ALLEN KEY	1
75050T-38	CAP SCREW 1/4 X 5/8	2	75050T-83	5 MM ALLEN KEY	1
75050T-39	RACK	1	70-910	1/4" - 6 MM CHISEL AND BIT (NOT SHOWN)	1
75050T-40	SLIDE PLATE	1	70-920	5/16" - 8 MM CHISEL AND BIT (NOT SHOWN)	1
75050T-41	MOTOR	1	70-930	3/8" - 10 MM CHISEL AND BIT (NOT SHOWN)	1
75050T-42	SET SCREW 5/16 X 3/4	3	70-940	1/2" - 13MM CHISEL AND BIT (NOT SHOWN)	1
75050T-43	HEX NUT 5/16	3			

NOTES

Notes

MODEL 75-050T M1



8360 Champ-d'Eau, Montreal (Quebec) Canada H1P 1Y3

Tel.: (514) 326-1161

Fax: (514) 326-5565 - Parts & Service / Fax: (514) 326-5555 - Order Desk

orderdesk@general.ca
www.general.ca

IMPORTANT

When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.